

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER :			
Misidentified ☐		Past Due ☐					

Work Order ID 153901***153901***

Page 2

Monday, November 28, 2016 2:17:17 PM

Item ID: D350-567-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/29/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/1/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-145 Location:FG033								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

DAS
27
9-89

DEC 09 2016

DAS
21
9-89

DEC 09 2016

VS 16/12/09

DAS
21
9-89

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OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 153901

153901

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/29/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

CB200		Purchased	No				Each	30.0000		1			
-------	--	-----------	----	--	--	--	------	---------	--	---	--	--	--

CB200

Acrylic Adhesive, 3.5G

DAS
6
9-89

DEC 08 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

PKG

30

m133800

1

m134943

1

m135407

4

m136020

24

D4730-020-030

Manufactured No

Each

0.0000

1

D4730-020-030

Velcro Strip 2.0W/ X 3.0L

120056

DEC 08 2016

DAS
27
9-89

D4971-041

Manufactured No

Each

0.0000

1

D4971-041

T/R Bellcrank Cover Assembly

153916

DEC 08 2016

DAS
27
9-89

D5076-041

Manufactured No

Each

0.0000

1

D5076-041

Fwd Bracket Assembly

153124

DEC 08 2016

DAS
27
9-89

D3802-1

Manufactured No

f

6.6579

2

D3802-1

Window Seal (\$ per foot)

2 feet

DAS
6
9-89

DEC 08 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST416

6.657930737

146267

0.000036

147802

6.65789474

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

DQA: _____ Date: _____



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		OTHER : ☐							

Picklist Print

Page 2

Monday, November 28, 2016 2:17:28 PM

Work Order ID: 153901

153901

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/29/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

D4435-9 Manufactured No

Each 4.0000 2

D4435-9

**

Bracket

DAS
27
9-89

Location

Loc Qty

Loc Code

ST098

4

152295

4

D4436-041 Manufactured No

Each 0.0000 1

D4436-041

**

Aft Bracket Assembly

DAS
27
9-89

Location

Loc Qty

Loc Code

ST422

0.0001

120932

0.0001

(D4441-240) CUT (1) AT 24.00" PER KIT

AN3-3A Purchased No

Each 189.0000 5

AN3-3A

**

Bolt

DEC 08 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST350

189

m135672

39

m135865

50

m136199

100

AN525-10R6 Purchased No

Each 285.0000 2

AN525-10R6

**

Screw

DEC 08 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST329

285

M134502

285

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Page 2

DQA: _____ Date: _____



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OTHER : ☐					

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Work Order ID: 153901

153901

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/29/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

AN525-832R7

Purchased

No

Each

156.0000

2

AN525-832R7

Screw

DEC 08 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

19

m134070

19

ST328

137

m134070

37

m136147

100

2

MS21042L06

Purchased

No

Each

108.0000

7

MS21042L06

Nut

DEC 08 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST303

108

m135766

8

m136199

100

7

MS21042L08

Purchased

No

Each

864.0000

2

MS21042L08

Nut

DEC 08 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

41

m135274

41

ST303

823

m135948

123

m135978

500

m136199

200

2

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Work Order ID: 153901

153901

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/29/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

2,125.000

5

MS21042L3

Nut

DEC 08 2016

Location

Loc Qty

Loc Code

CCK007

600

M136192

600

FP001

100

m135945

100

GA

196

m134360

108

m135135

88

OVER007

600

M136044

600

ST303

629

m135767

129

m135945

500

Each

138.0000

2

MS21059L3

Purchased

No

MS21059L3

Nut Plate

DEC 08 2016

Location

Loc Qty

Loc Code

GA

27

M135603

27

ST301

111

M135774

46

M136047

65

Each

340.0000

7

MS35206-229

Purchased

No

MS35206-229

Screw

DEC 08 2016

Location

Loc Qty

Loc Code

ST271

340

M135603

340

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153901

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/29/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

Each

1,937.000

10

NAS1149F0332P

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

343

m133709

343

ST262

1594

m135948

1594

Each

176.0000

14

NAS1149FN616P

Purchased

No

NAS1149FN616P

WASHER

DAS
27
9-89

Location

Loc Qty

Loc Code

ST264

176

M135274

4

M136199

172

Each

424.0000

2

NAS1149FN816P

Purchased

No

NAS1149FN816P

WASHER

DAS
27
9-89

Location

Loc Qty

Loc Code

ST263

424

117316

424

DEC 08 2016
DAS 27 9-89

DEC 08 2016
DAS 27 9-89

DEC 08 2016
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				OTHER :					

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. E OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-18

FAA STC: SH989NE

FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141/-143/-145 Close-out Kits, which are intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141/-143/-145 Floor Window Close-out Kits provide a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1. The -143 Kit is identical to the -141 Kit with the exception of the D4971-041 T/R Bellcrank Cover Assy which replaces the D4435-045 T/R Bellcrank Cover Assy on aircraft fitted with energy attenuating seats. The -145 Kit is similar to the -143 Kit but is only kit compatible with the AS350 B3e aircraft.

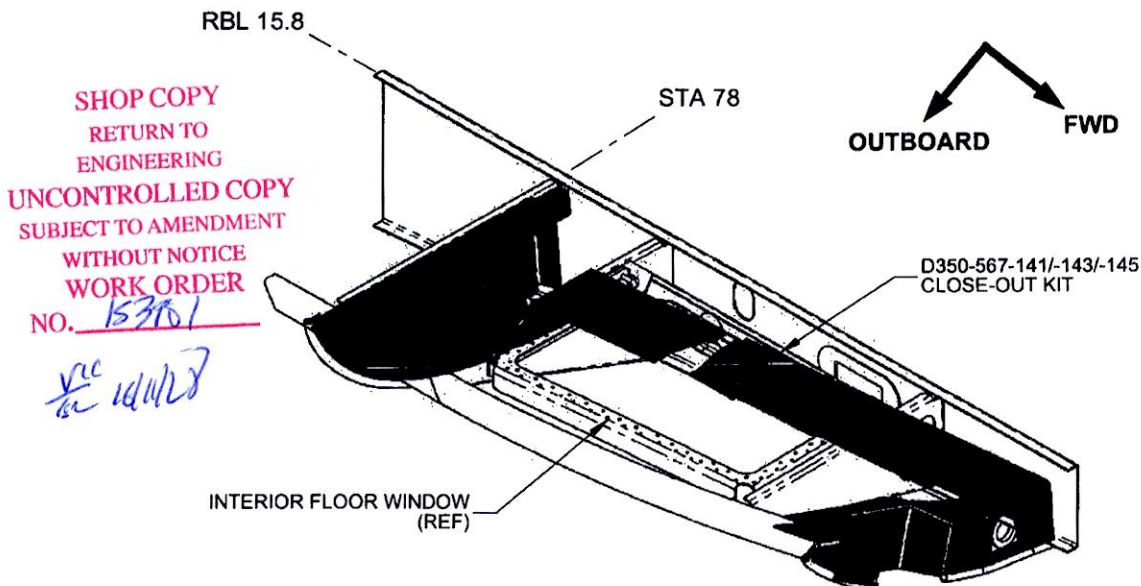


Figure 1. Floor Window Close-out Kit Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

F	ADDED D4434-047 TO -141 KIT SEE PAR14-372.	AJS	15.01.12
E	ADD -143/-145 KITS	RF	14.03.20
E	CLARIFY FIGURES 3-12	VS	13.09.11
C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
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DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
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Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

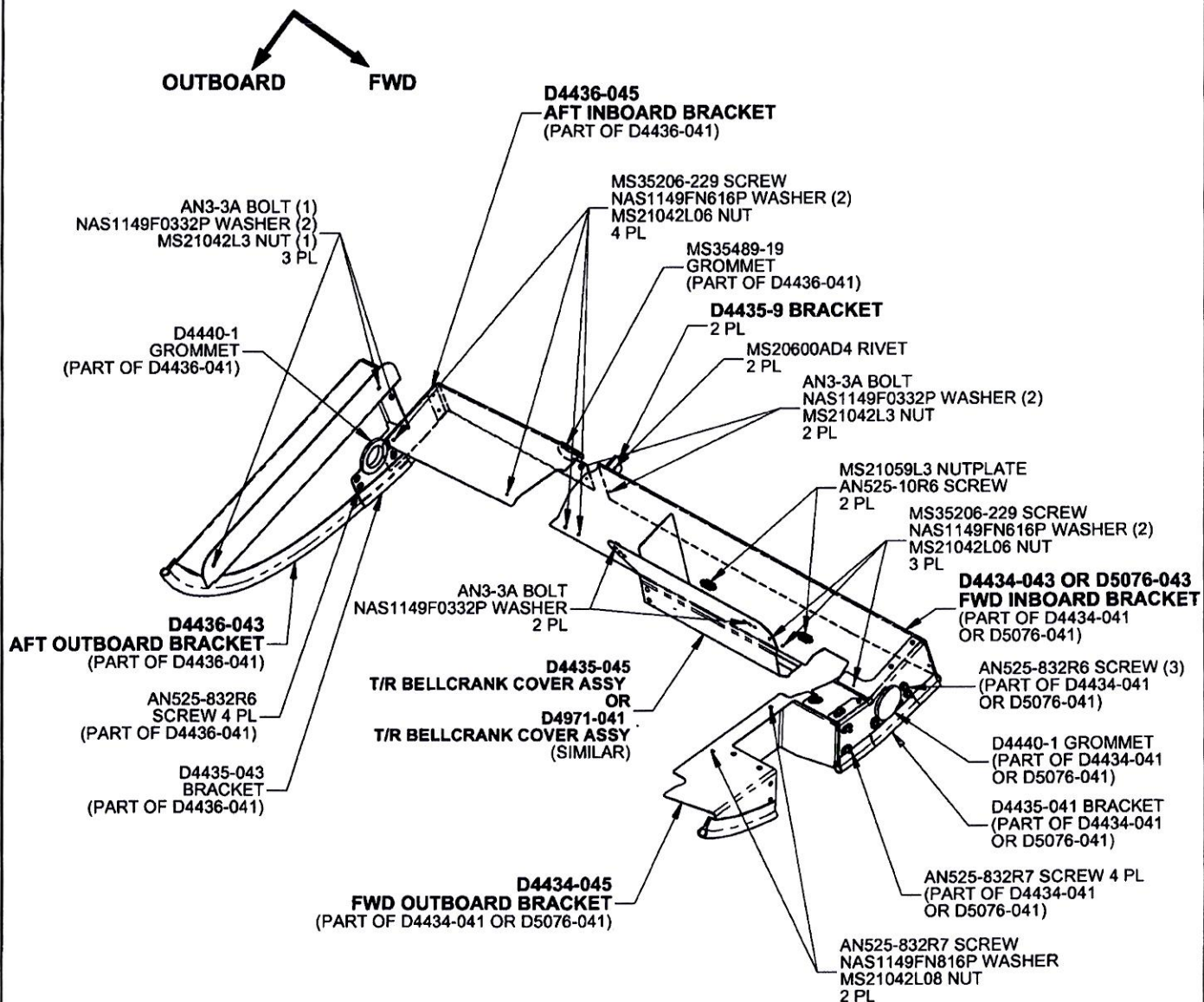


Figure 2. Floor Window Close-out Kit Installation

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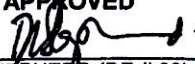
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Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

- 4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:
- Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
 - Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.
- 4.2 Temporarily install D4434-043/D5076-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 /D5076-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.
- F** 4.3 For -141 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.4 For -143 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4971-041 T/R Bellcrank cover as shown in Figure 13b. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.5 For -145 installations, if aircraft is equipped with Collective Circuit Breaker Board box, use D5076-043 Fwd Inboard Bracket as shown in Figure 13c. Install D4971-041 T/R Bellcrank cover as shown in Figure 13c. Note: Confirm the D5076-3 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.6 Drill out rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043/D5076-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes for D4434-043/D5076-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043/D5076-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.
- 4.7 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.
- 4.8 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.
- 4.9 Drill a pilot hole from D4435-9 Bracket to the D4434-043/D5076-043 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.
- 4.10 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 screws, NAS1149FN816P washer and MS21042L08 nuts.
- 4.11 FOR D350-567-141 KIT**
- Align D4435-045 T/R Bellcrank Cover Assy with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12a.
 - Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover Assy to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12a and Figure 13a. Install D4435-045 T/R Bellcrank Cover Assy using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12a and Figure 13a.

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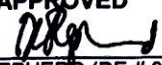
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		OTHER :							

4.12 FOR D350-567-143/-145 KIT

- a) Remove the D4972-041 Side Plate Assy from the D4971-041 T/R Bellcrank Cover Assy and retain fasteners.
 - b) Align D4971-1 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12b.
 - c) Bond D4730-020-030 Velcro to back of D4971-1 T/R Bellcrank Cover as shown in Figure 12b using CB 200 adhesive.
 - d) Transfer drill 2 x $\varnothing 0.098$ holes from D4971-1 Cover Plate to D4434-043/D5076-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043/D5076-043 Fwd Inboard Bracket as shown in Figure 13b/13c. Install D4971-1 Cover Plate using AN525-10R6 screws and D4730-020-030 Velcro per Figure 12b and Figure 13b/13c.
 - e) Re-install the D4972-041 Side Plate Assy using the retained fasteners.
- 4.13 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.14 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.15 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.16 Ensure there is a gap between the components of the D350-567-141/-143/-145 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-141 /-143/-145 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

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Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
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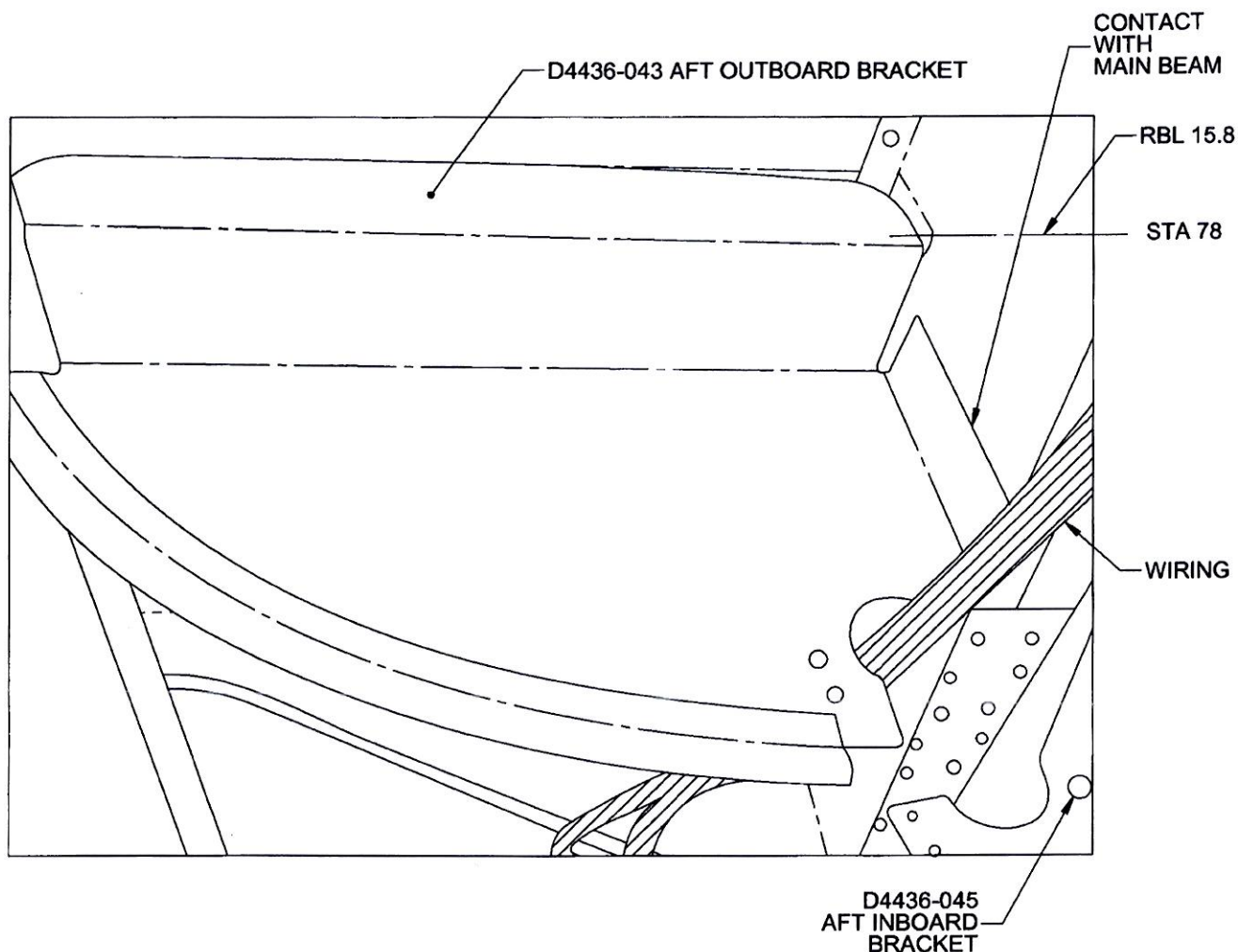


Figure 3. D4436-043 Aft Outboard Bracket Installation

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER : _____							
Misidentified	☐	Past Due								

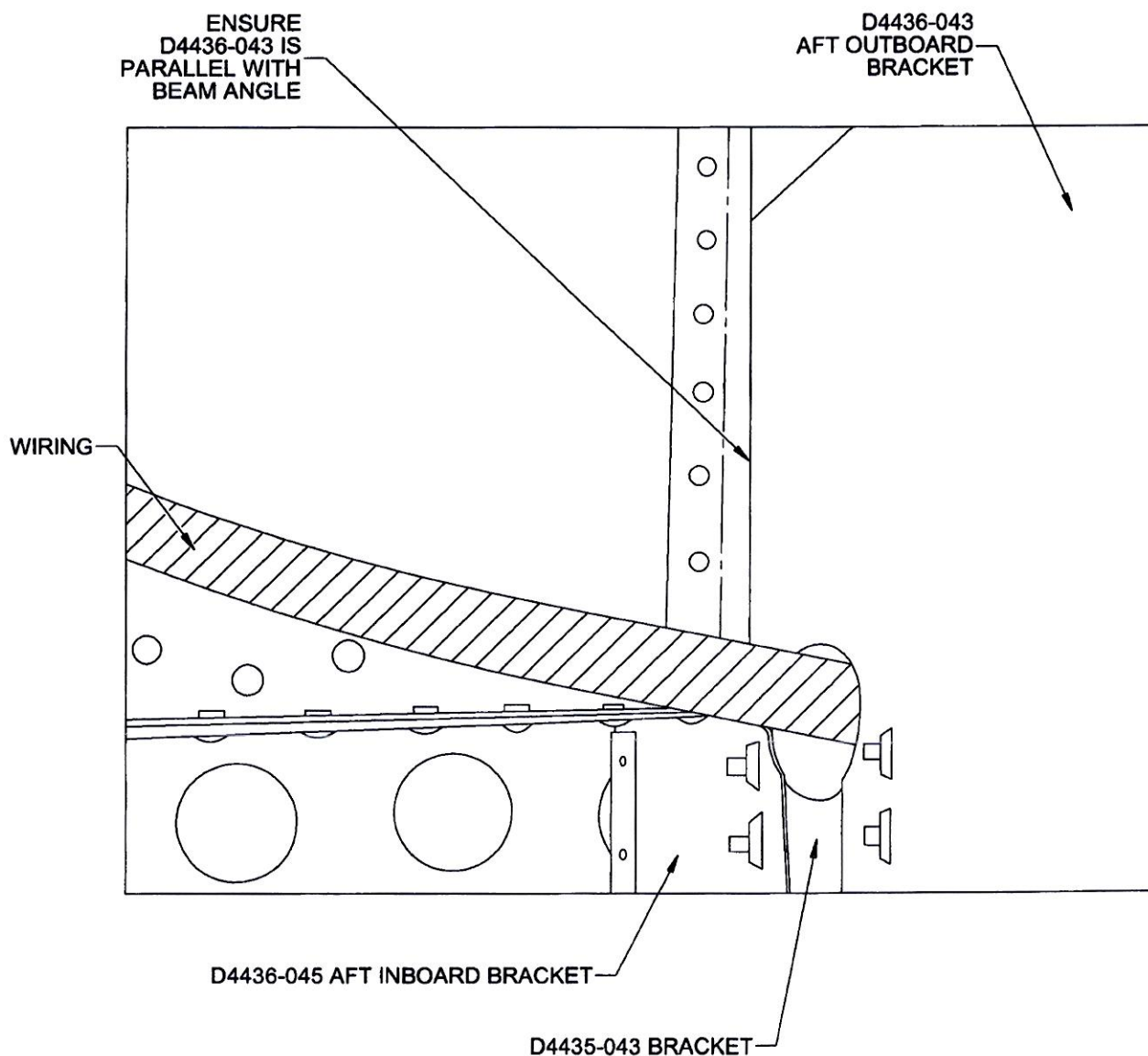


Figure 4. D4436-043 & D4435-043 Brackets Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

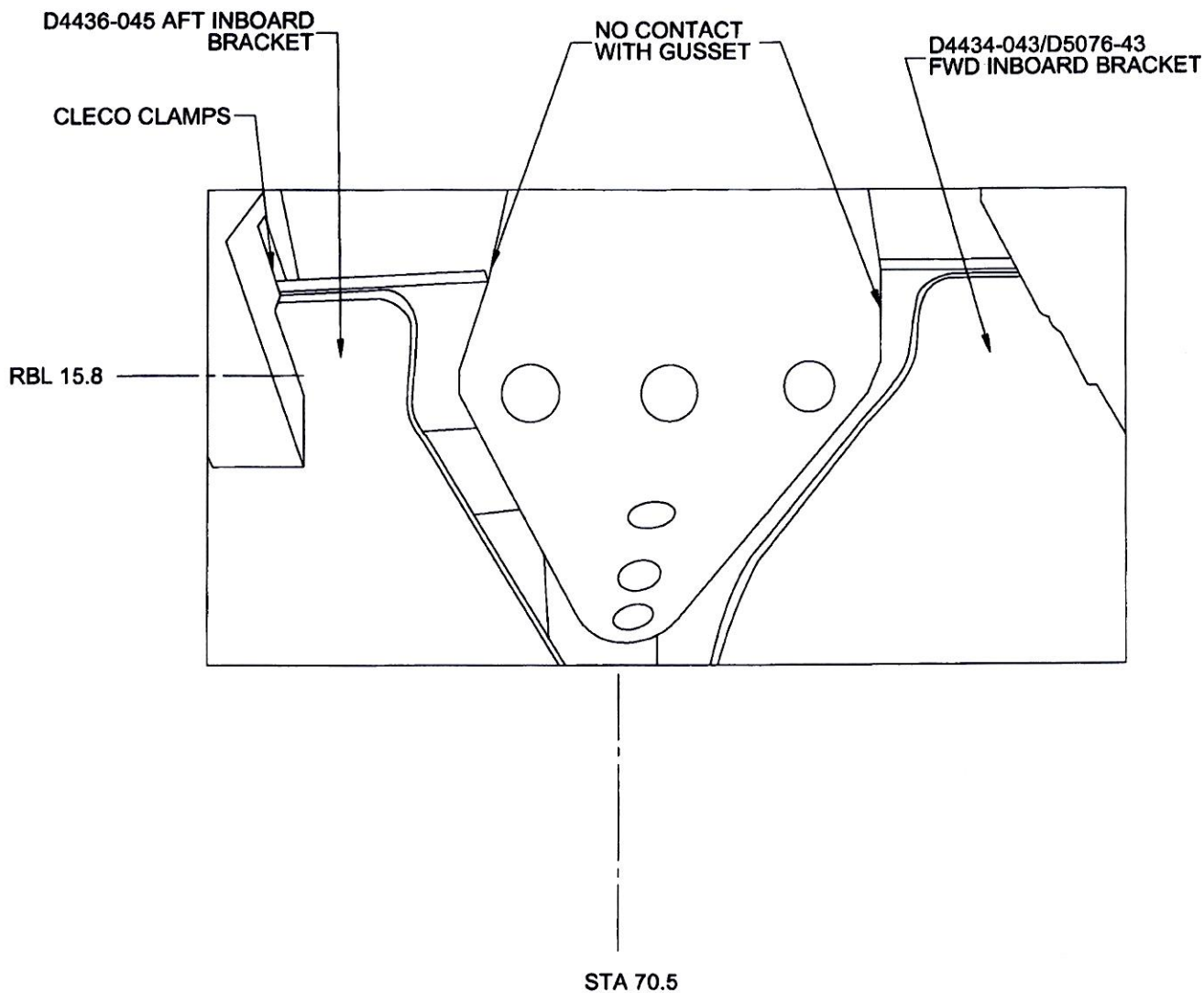


Figure 5. D4436-045 & D4434-043/D5076-043 Brackets Installation

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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D. SHEPHERD (DE # 02)

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER :			
Misidentified ☐		Past Due ☐					

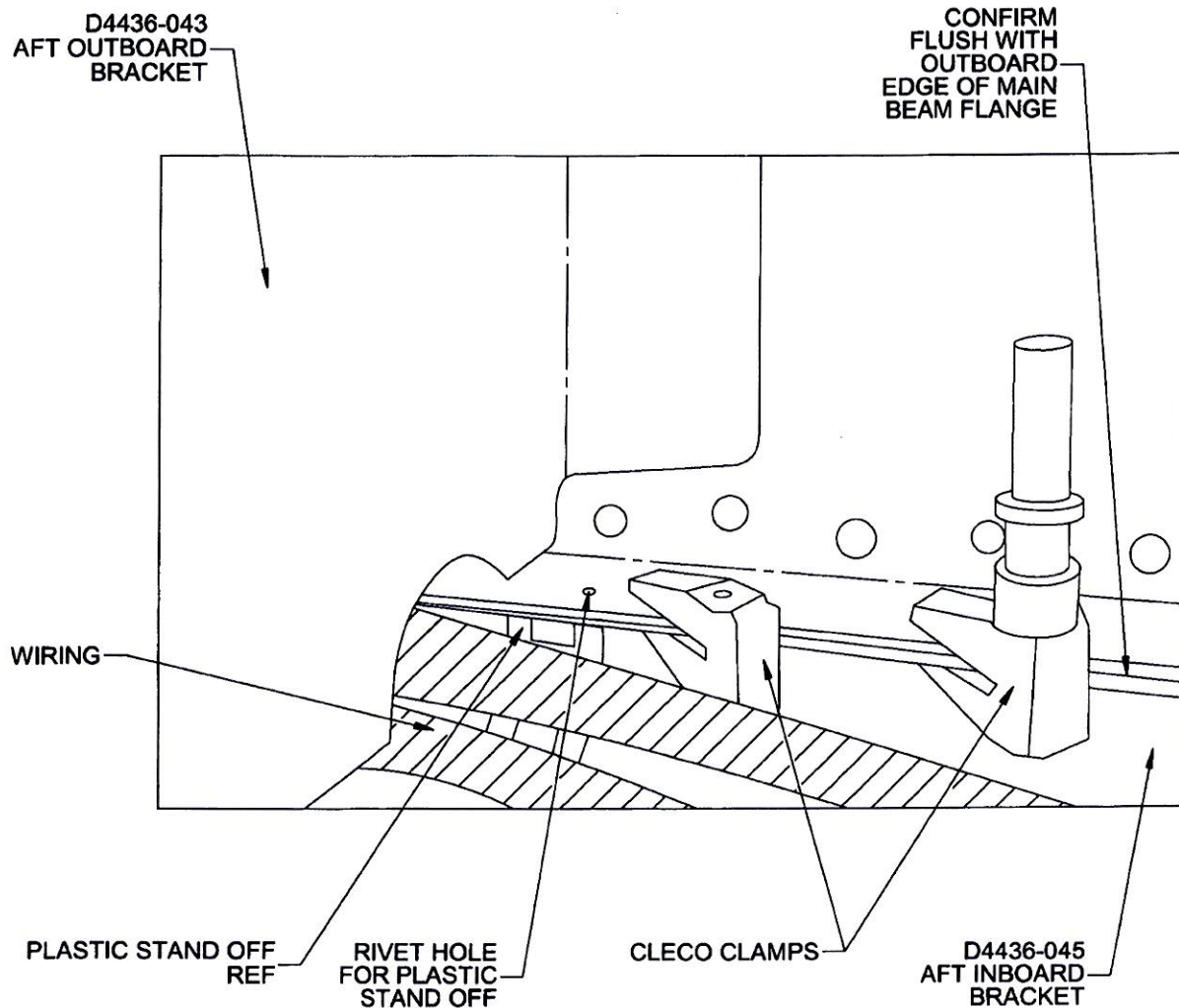


Figure 6. D4436-043 & D4436-045 Brackets Installation

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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D. SHEPHERD (DE # 02)

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

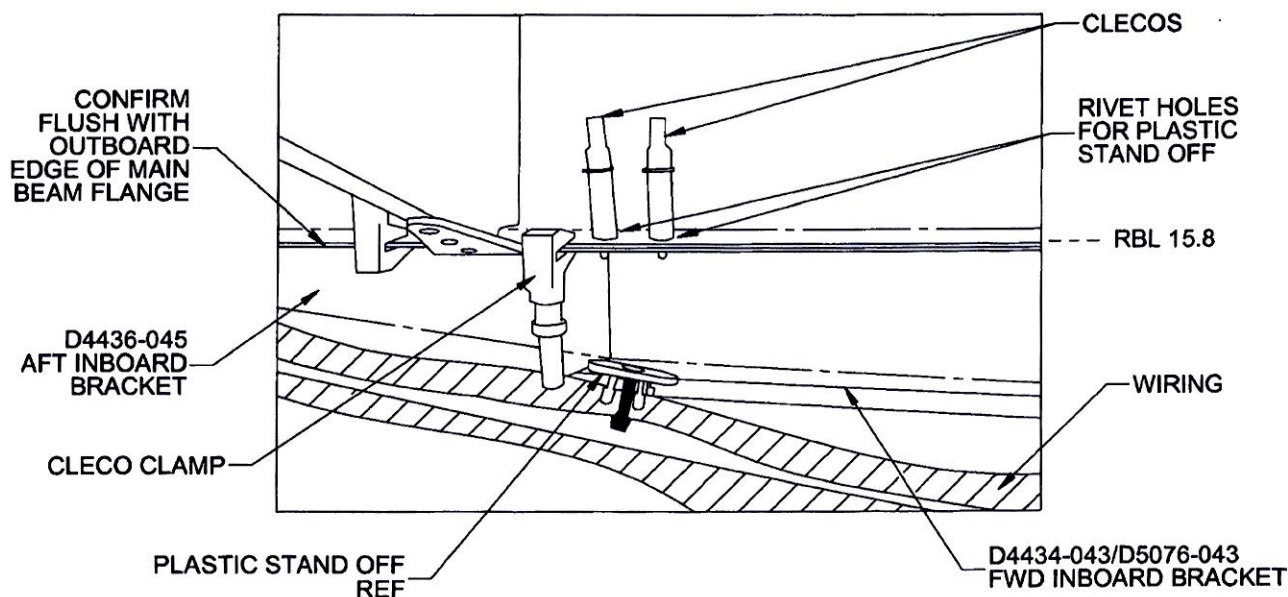


Figure 7. D4434-043/D5076-043 & D4436-045 Brackets Installation

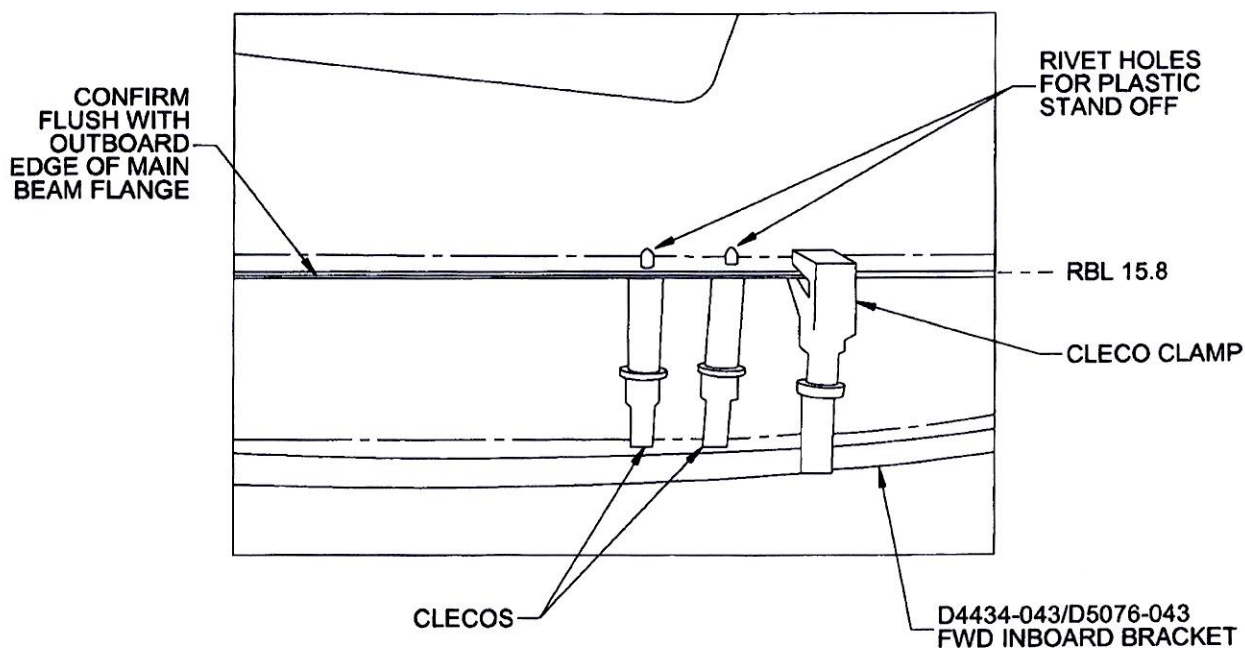


Figure 8. D4434-043/D5076-043 Fwd Inboard Bracket Installation

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

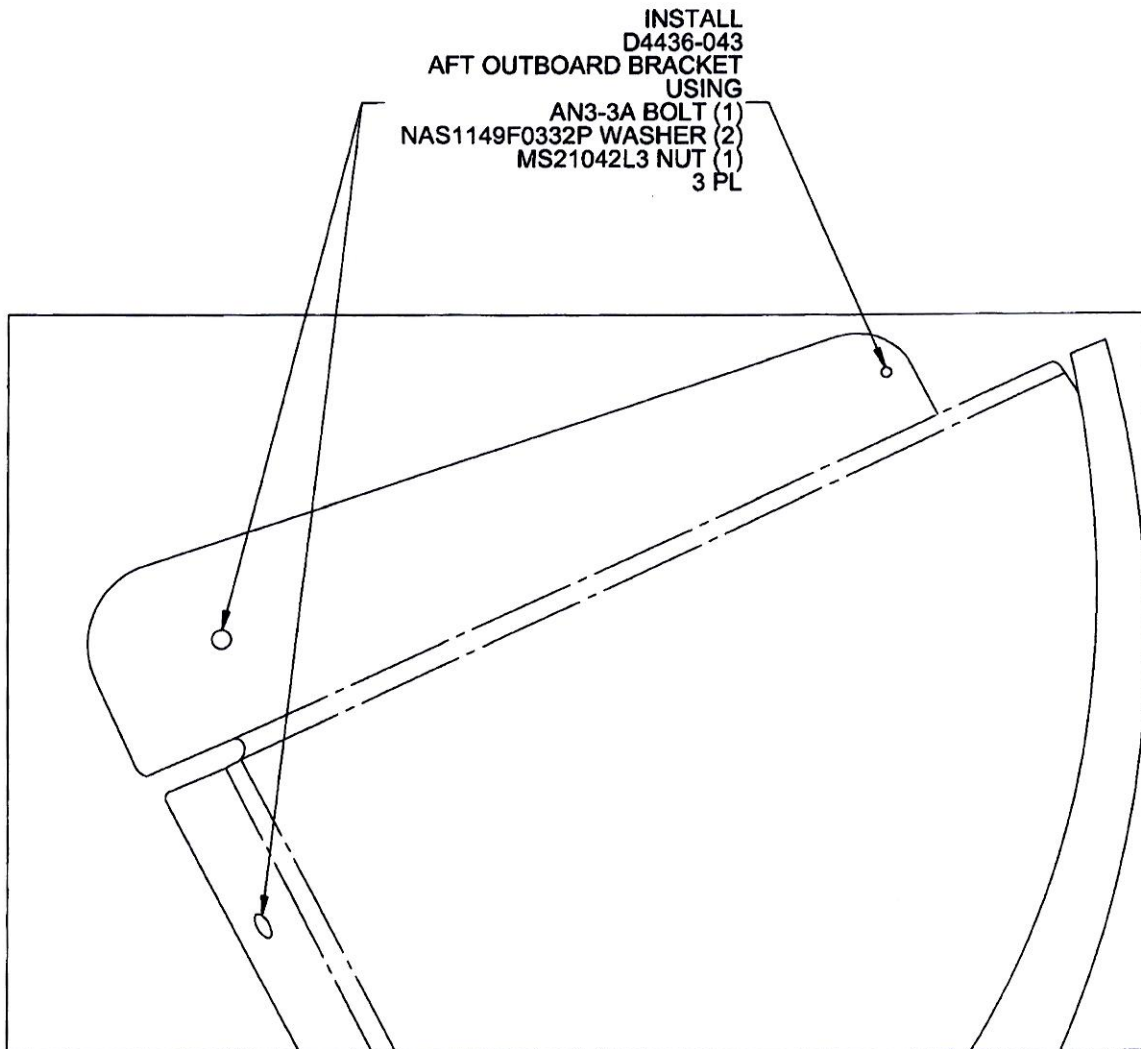


Figure 9. D4436-043 Aft Outboard Bracket Installation

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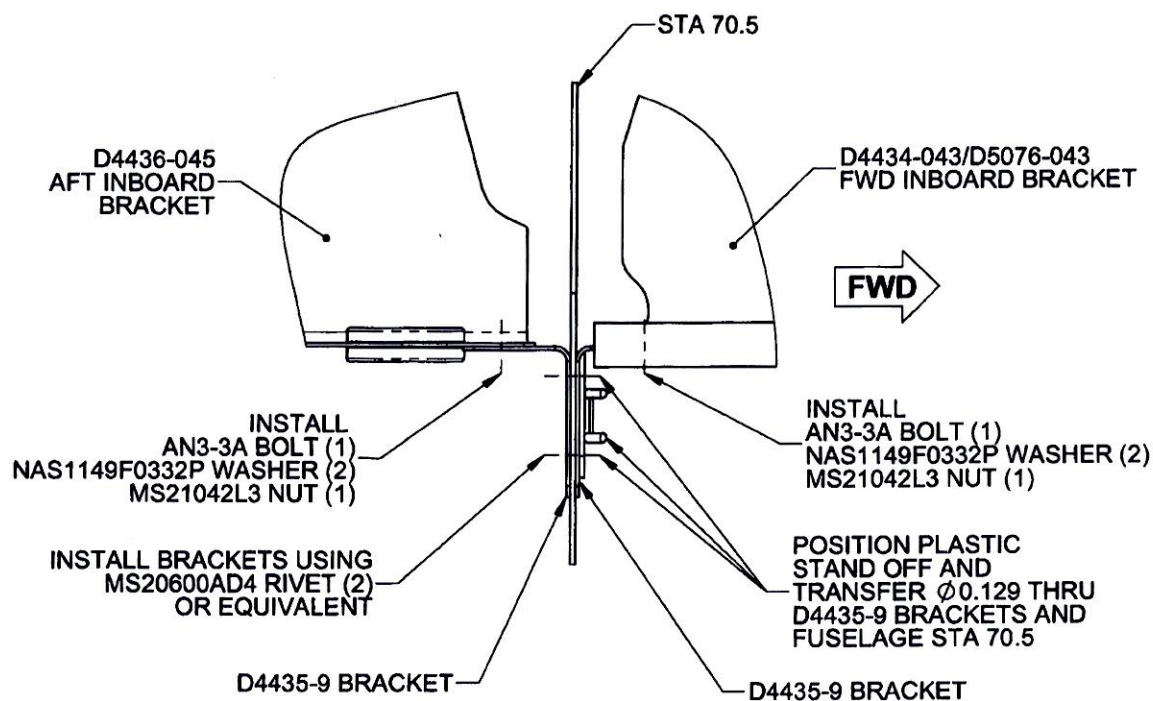
WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : _____			



LOOKING UP AT STA 70.5

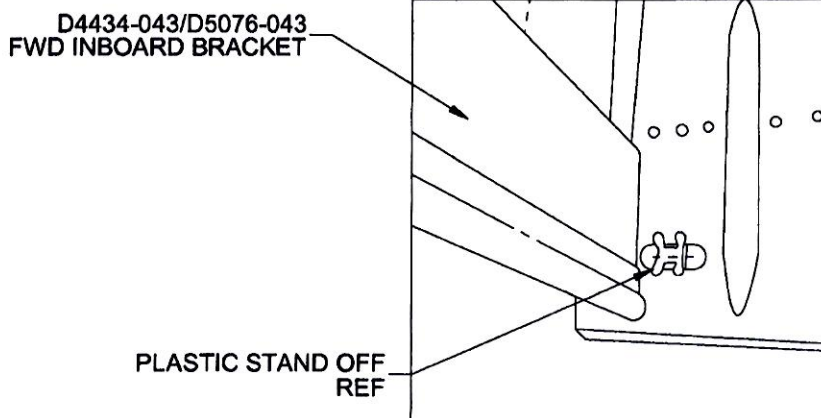


Figure 10. D4434-043/D5076-043 and D4435-9 Brackets Installation

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BRANCH
DAO # 01-O-01

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

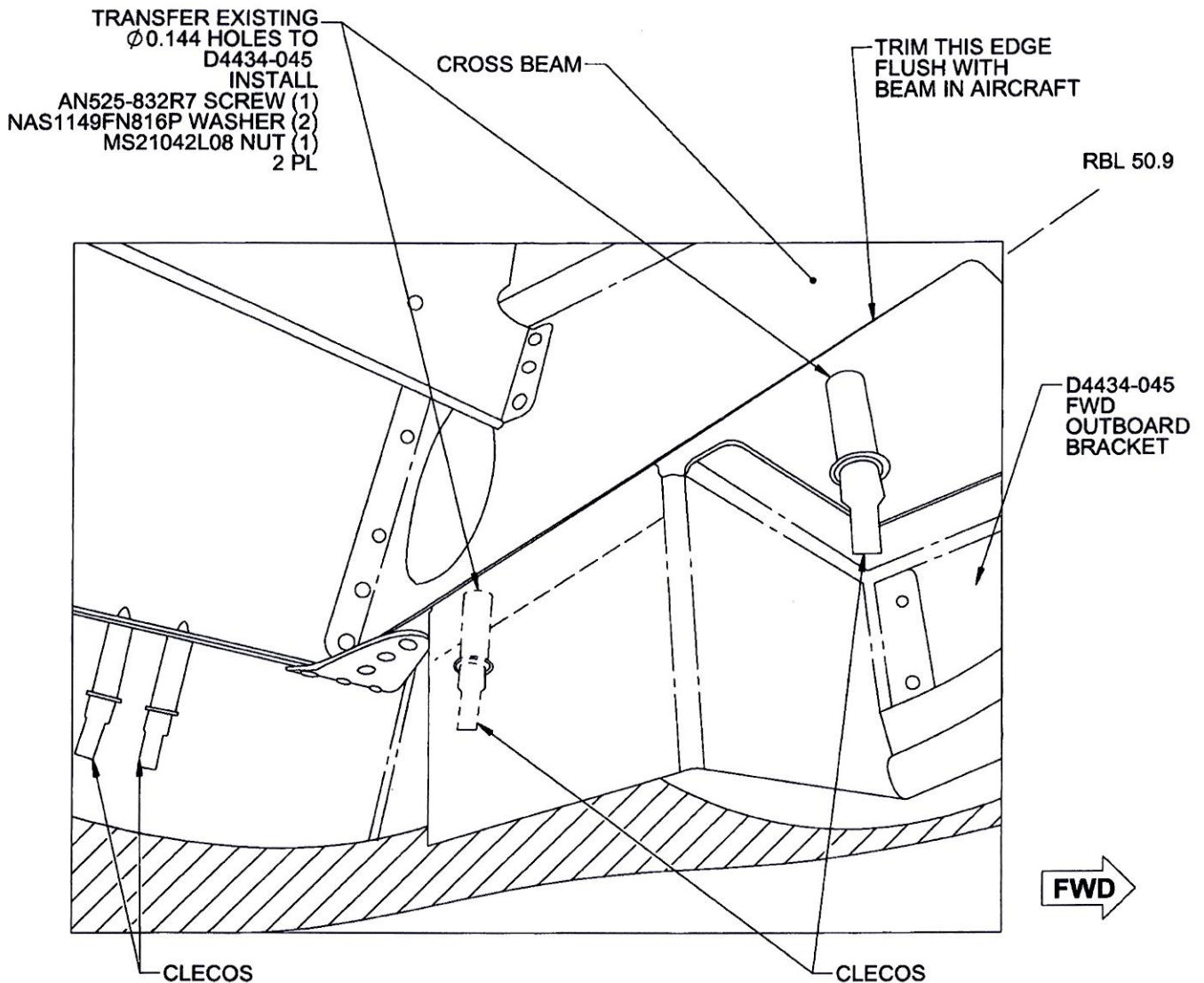


Figure 11. D4434-045 Bracket Installation

CANADA
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

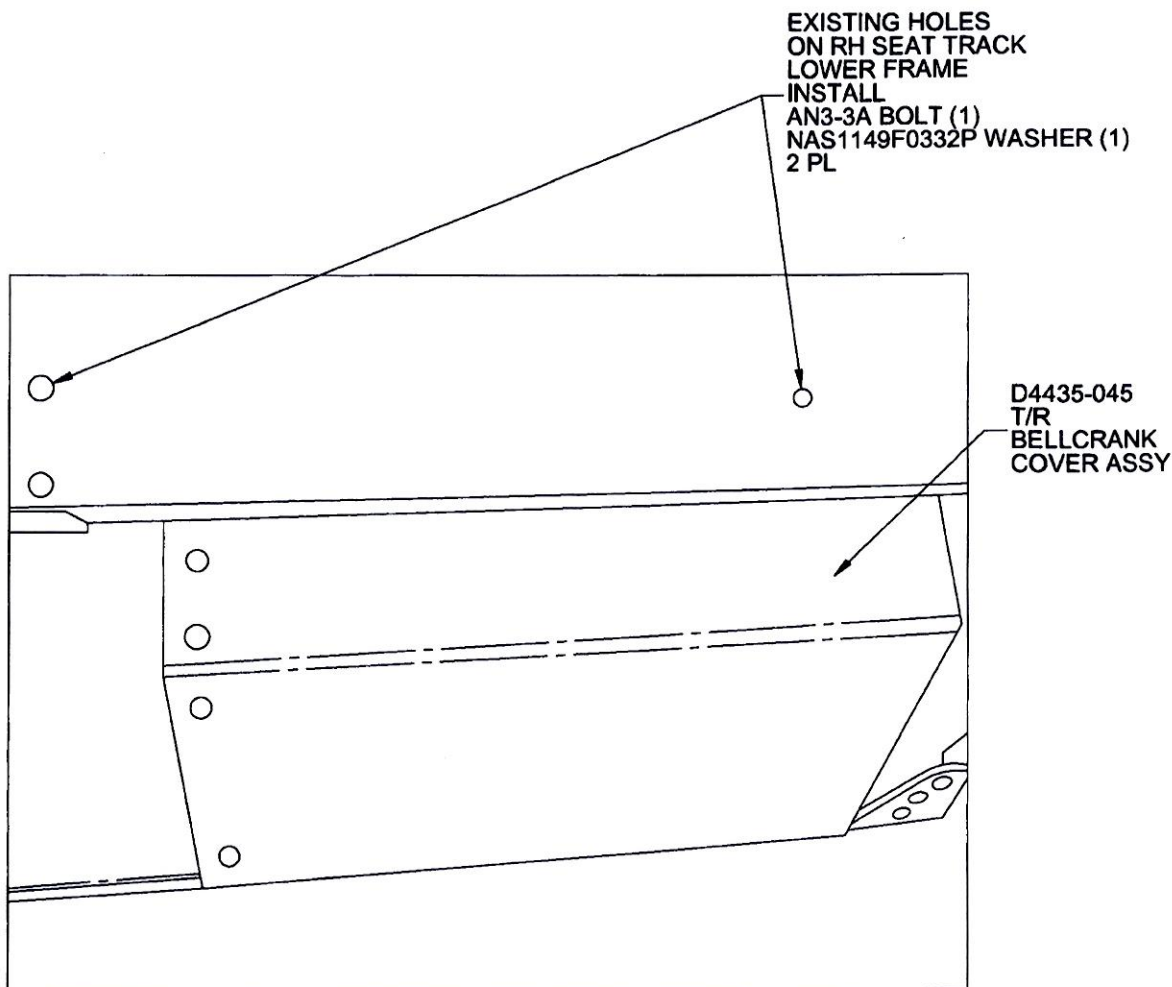


Figure 12a. D4435-045 T/R Bellcrank Cover Installation (-141)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

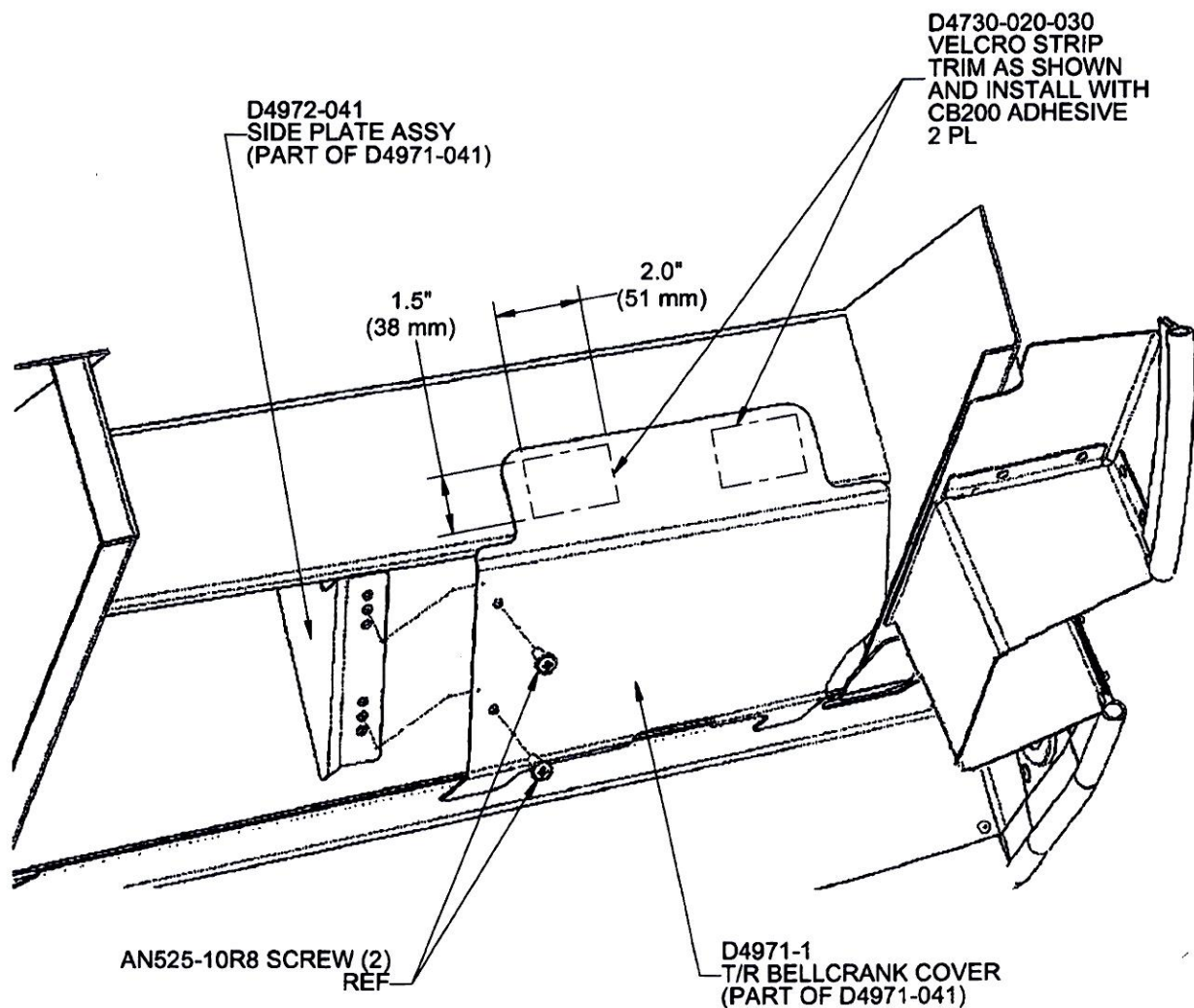


Figure 12b. D4971-041 T/R Bellcrank Cover Assy Installation (-143/-145)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	SHEET 15 OF 19	
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY						
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐		Drawing ☐
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____						
Misidentified ☐		Past Due ☐								

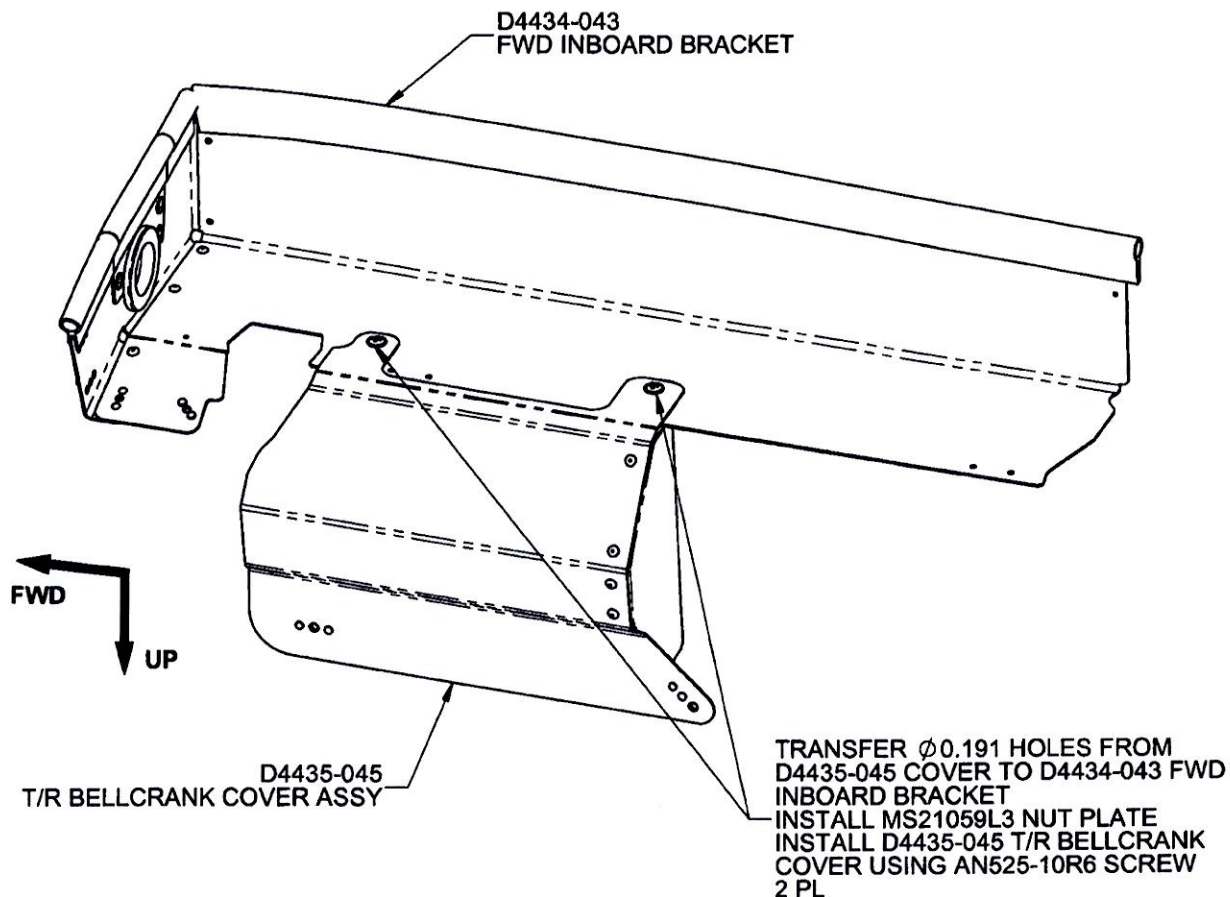


Figure 13a. D4435-045 Cover Installation (-141 ONLY)

CANADA
DEPARTMENT OF TRANSPORT
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BRANCH
DAO # 01-O-01

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D. SHEPHERD (DE # 02)

DATE: 15.01.12
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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

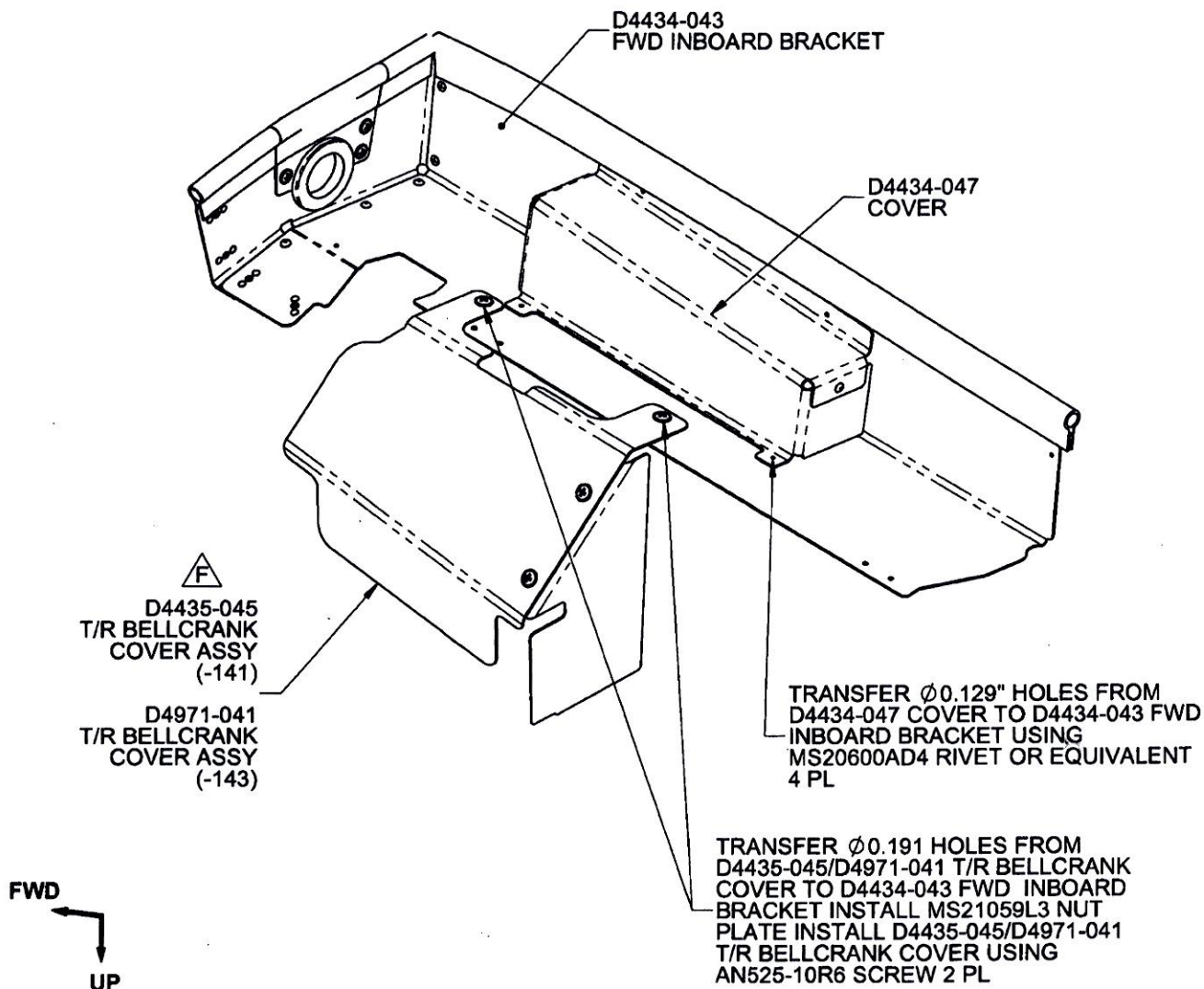


Figure 13b. D4971-041/D4435-045 & D4434-047 Cover Installation △
(D4434-047 is Optional on -141)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

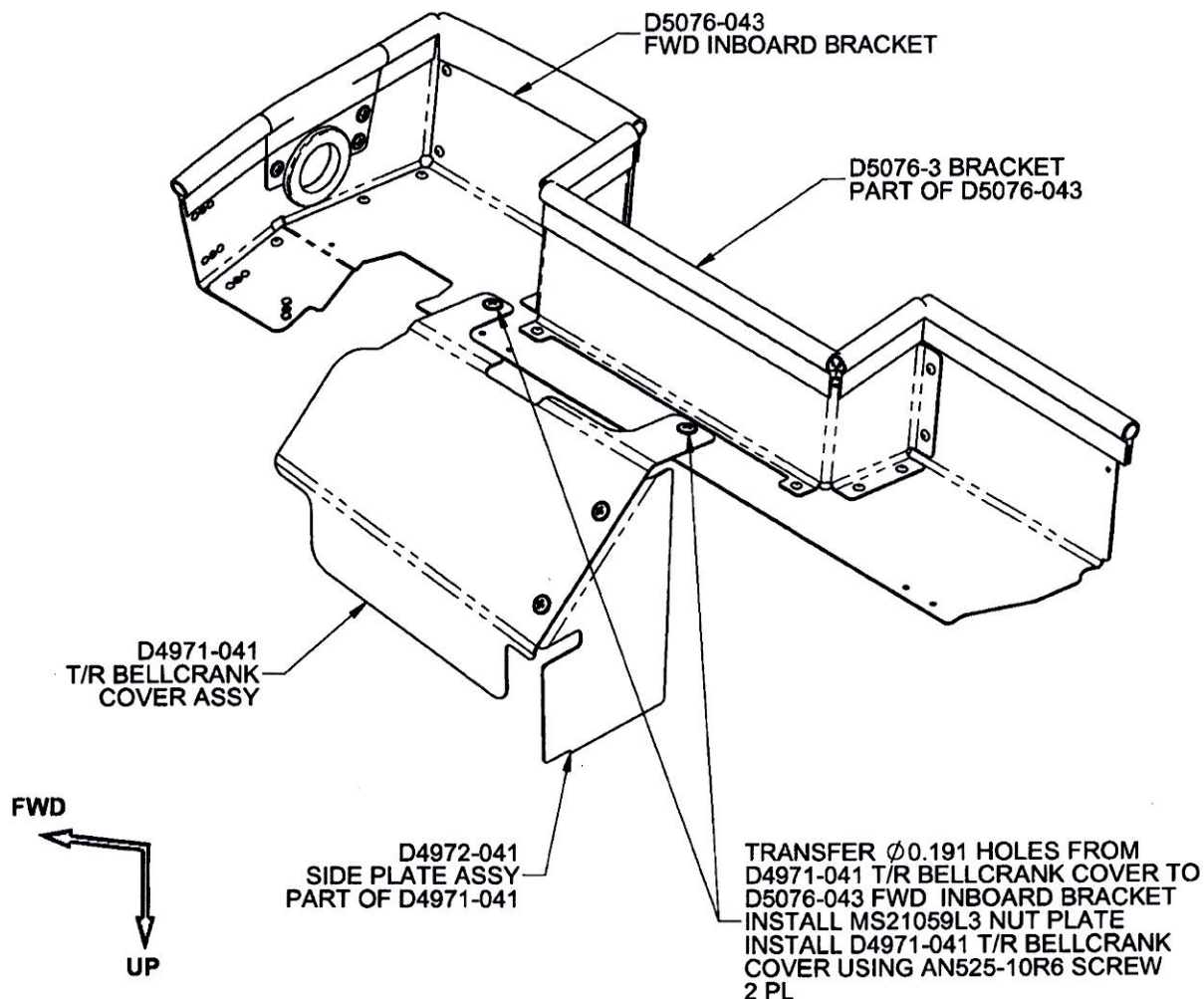


Figure 13c. D4971-041 INSTALLATION INTO D5076-043 (-145 ONLY)

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BRANCH
DAO # 01-O-01

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

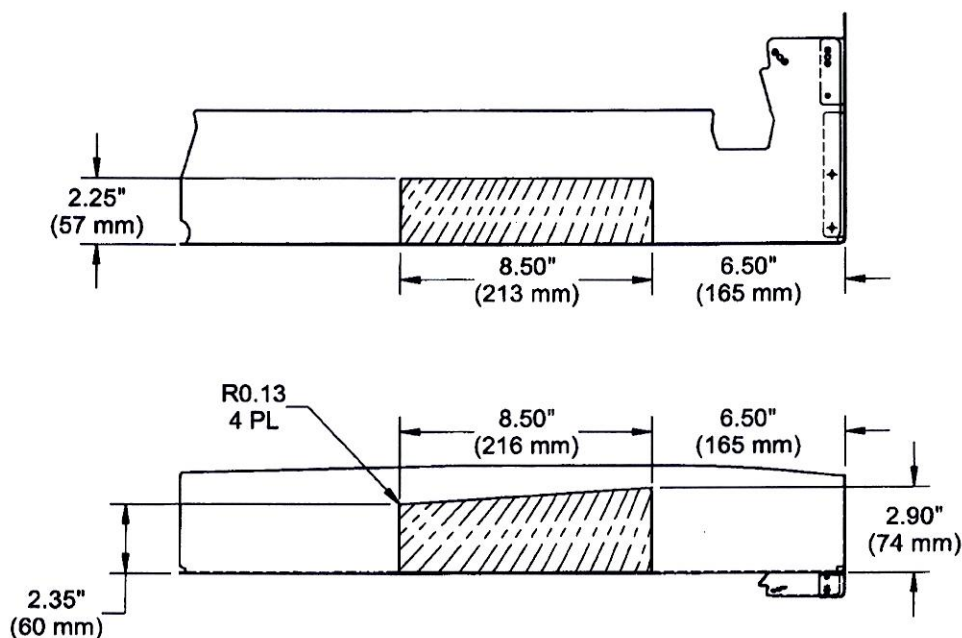
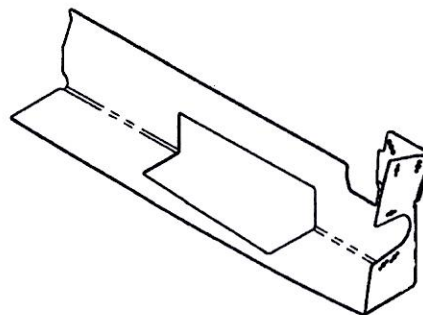


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

CANADA
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BRANCH
DAO # 01-O-01

APPROVED

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D. SHEPHERD (DE # 02)

DATE: 15.01.12
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	DSI 9590	SHEET 19 OF 19
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

REFERENCE ONLY

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-k-g	1.66 m	2.94 m-k-g

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)
DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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